

Date: Thursday, 04/09/2008 12:55:50 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WINDOW SEAL TOOL
<b>Job Number</b> : 41813	
<b>Estimate Number</b> : 12558	
<b>P.O. Number</b> :	<b>Part Number</b> : D35611
<b>This Issue</b> : 04/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3561 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 32210	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/09/2008 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est:A 06/10/19 New issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S11GA	304/316 0.125 Sheet
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**Comment:** Qty.: 0.0497 sf(s)/Unit Total: 0.2483 sf(s)

304/316 .125 Sheet

Batch: 108156 HB 8-9-5

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3561

Dwg Rev: A HB 8-9-5

Prog Rev: A

2-Deburr if necessary HB 8-9-5

⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 02/09/05 (x6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

N/A S 8/9/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		RC:						

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW SEAL TOOL

Job Number: 41813

Part Number: D35611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3561

SB 08/09/09 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/09 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 109

8/9/9

(X)

SB

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10/09

Job Completion



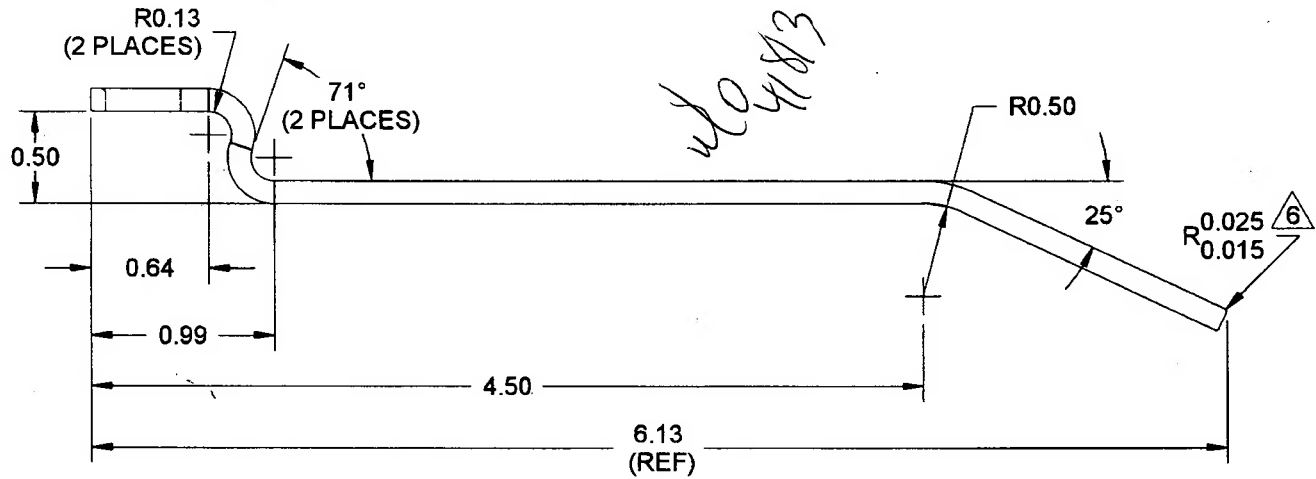
MF

08-09-09

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. A  
DRAWING NO. D3561  
SHEET 1 OF 1  
SCALE 1:1  
TITLE SEAL INSERT TOOL

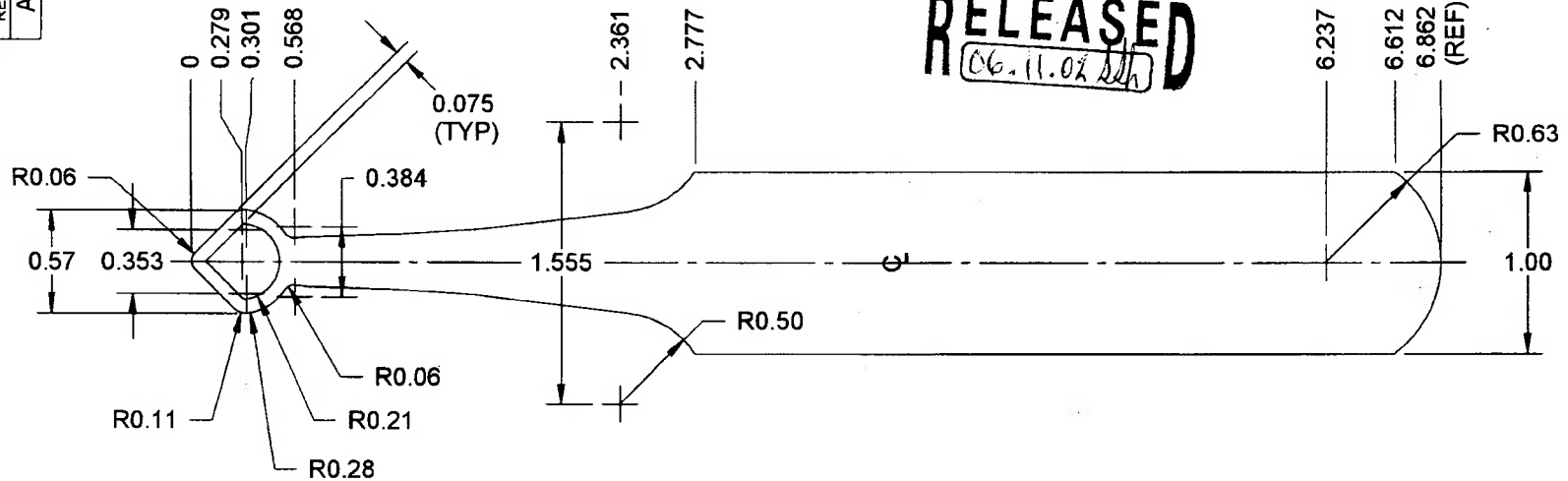
DESIGN BY [Signature]  
CHECKED PH  
DATE 06.10.06  
REV. A  
DATE 06.10.06  
DESCRIPTION NEW ISSUE



### D3561-1 SEAL INSERT TOOL

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



### D3561-1F SEAL INSERT TOOL FLAT PATTERN

**RELEASED**  
06.11.02

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